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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

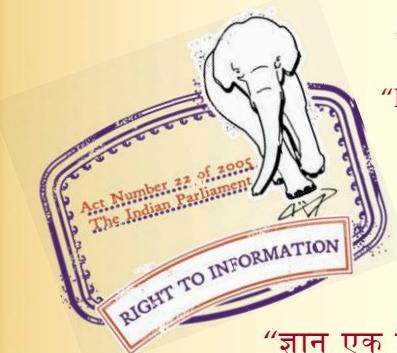
“Step Out From the Old to the New”

IS 6710 (1977): Centre Drills Type R [PGD 32: Cutting tools]

“ज्ञान से एक नये भारत का निर्माण”

Satyanaaran Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartṛhari—Nītiśatakam

“Knowledge is such a treasure which cannot be stolen”



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AMENDMENT NO. 1 OCTOBER 1983

TO

IS:6710-1977 SPECIFICATION FOR CENTRE DRILLS TYPE R

(First Revision)

Corrigendum

(Page 1, clause 2, figure) - Delete the included
angle $60^\circ - 1^\circ$.

(EDC 45)

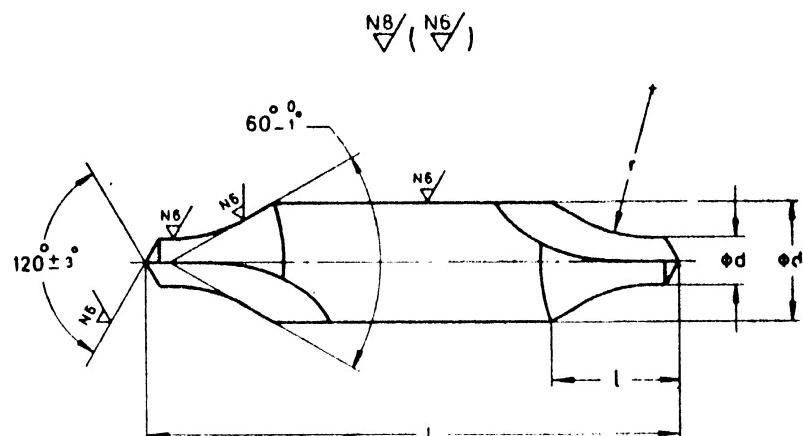
Reprography Unit, ISI, New Delhi, India



Indian Standard
SPECIFICATION FOR
CENTRE DRILLS TYPE R
(First Revision)

1. Scope — Covers the dimensions and requirements for centre drills type R, suitable for centre holes with radius form according to IS : 2473-1975 'Dimensions for centre holes'.

2. Dimensions



All dimensions in millimetres.

| <i>d</i> k12 | <i>d</i> ₁ <i>h9</i> | <i>L</i> | | <i>I</i> | <i>r</i> | |
|-----------------|------------------------------------|----------|------|----------|----------|------|
| | | Max | M/n | | Max | Min |
| 1.0 (1.25) | 3.15 | 33.5 | 29.5 | 3.0 | 3.15 | 2.5 |
| 1.6 | 4.0 | 37.5 | 33.5 | 3.35 | 4.0 | 3.15 |
| 2.0 | 5.0 | 42 | 38 | 4.25 | 5.0 | 4.0 |
| 2.5 | 6.3 | 47 | 43 | 5.3 | 6.3 | 5.0 |
| 3.15 | 8.0 | 52 | 48 | 6.7 | 8.0 | 6.3 |
| 4.0 (5.0) | 10.0 | 59 | 53 | 8.5 | 10.0 | 8.0 |
| | 12.5 | 66 | 60 | 10.6 | 12.5 | 10.0 |
| 6.3 (8.0) | 16.0 | 74 | 68 | 13.2 | 16.0 | 12.5 |
| 10.0 | 20.0 | 83 | 77 | 17.0 | 20.0 | 16.0 |
| | 25.0 | 103 | 97 | 21.2 | 25.0 | 20.0 |
| | | | | 26.5 | 31.5 | 25.0 |

Note — Non-preferred sizes are given within brackets.

3. Material — High speed steel.

Note — Unless otherwise specified, the high speed steel shall be according to T83W6Mo5Cr4V2 or T70W18Cr4V1 according to IS : 7291-1974 'High speed tool steels' or equivalent, in which case the major constituents shall be specified by the manufacturer.

4. Hardness — 760 HV M/n
900 HV Max

5. General Requirements

5.1 The flutes may be straight or spiral at the discretion of the manufacturer.

5.2 Hand of cutting, unless otherwise specified : Right.

5.3 The tolerance on dimensions without any specified tolerances shall be of grade 'medium' according to IS : 2102-1969 'Allowable deviations for dimensions without specified tolerances (first revision)'.

5.4 The drills shall be manufactured in one piece and shall be free from cracks and burrs.

5.5 The two cutting edges of the centre drill shall be diametrically opposite.

5.6 The drill shall be properly sharpened and ready for use.

6. Sampling — The sampling and criteria of acceptance shall be in accordance with IS : 7778-1975 'Methods for sampling small tools'.

7. Designation — A centre drill type R, with radius form having pilot diameter $d = 1.6$ mm and shank diameter $d_1 = 4.0$ mm and conforming to this standard shall be designated as:

Centre Drill R 1.6 x 4.0 IS : 6710

8. Marking — Shall be marked with type pilot diameter d , shank diameter d_1 and manufacturer's name or trade-mark.

8.1 ISI Certification Marking — Details available with the Indian Standards Institution.

9. Preservative Coating and Packing

9.1 Each centre drill shall be covered with a suitable rust proofing material.

9.2 Each centre drill or a number of centre drills shall be wrapped in non-absorbent paper protected by a cover bearing the type, pilot diameter and shank diameter of the centre drill and manufacturer's name or trade-mark.

9.3 One size of centre drills shall be packed in one carton.

EXPLANATORY NOTE

This standard was first published in 1972. The present revision has been taken up to keep it in line with the work done at ISO level. This standard is in full conformity with ISO 2541-1972 'Centre drills for centre holes with radius form—Type R' issued by International Organization for Standardization.